

Work Order ID 51907

Wednesday, September 09, 2009 11:10:57 A



Page 1

Item ID: D3794-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gasket

Start Date: 9/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: B

Date: 09-9-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3794

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3794

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Deburr if necessary

B 9-9-10



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-9-10

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) Sordosio



4

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Item ID: D3794-3	Accept		Setup Start	
Revision ID: A			Stop	
Item Name: Gasket				
Start Date: 9/10/2009	Start Qty: 12.00		Cust Item ID:	
Required Date: 9/18/2009	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: FP14	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/9/10 (122) 50

09/09/11 *[Signature]*

W 09-09-11

Picklist Print

Page 1

Wednesday, September 09, 2009 11:10:57 AM

Work Order ID: 51907



Parent Item: D3794-3RevA



Parent Item Name: Gasket

Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	320.4821	16.2038			
NEOPRENE SHEET 0.063												

189-9-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	320.4820585	
111853	-4.147E-05	
112508	320.4821	

112508

DART AEROSPACE LTD		Work Order: 57907
Description: Gasket		Part Number: D3794-3
Inspection Dwg: D3794	Rev: A	Page 1 of 1

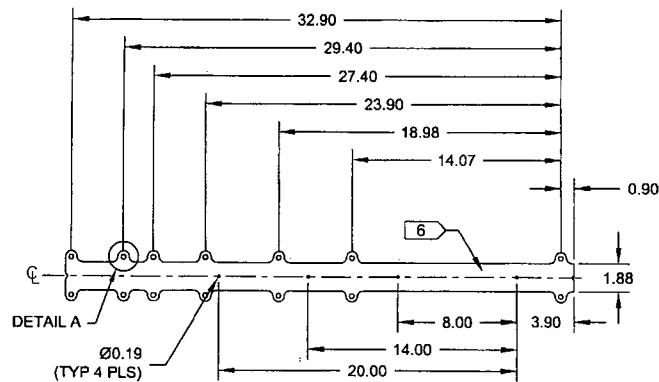
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

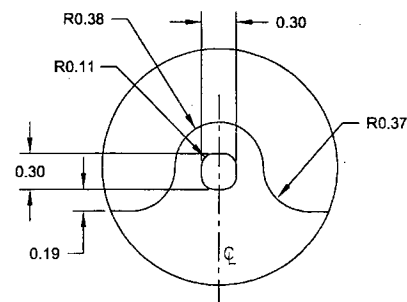
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.193	*			
0.300 x 0.300	+/-0.010	306 x 304	*			
1.88	+/-0.030	1.886	*			
4.281	+/-0.010	4.286	*			
6.44	+/-0.030	6.433	*			
6.00	+/-0.030	6.00	*			
6.75	+/-0.030	6.75	*			
2.00	+/-0.030	2.003	*			
4.75	+/-0.030	4.75	*			
9.50	+/-0.030	9.50	*			
14.25	+/-0.030	14.25	*			
17.75	+/-0.030	17.75	*			
26.74	+/-0.030	26.74	*			
29.23	+/-0.030	29.23	*			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-10	Date: 09/09/10	Date:	N/A

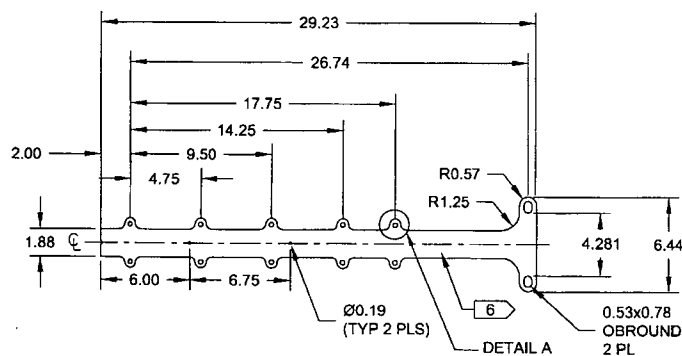
Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD	



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51907

RELEASED
08-05-14

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.14			

DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D3794
TITLE GASKET
SCALE NTS
REV. A
SHEET 1 OF 1
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